

Work Order ID 57645

April 12, 2010 3:20:45 PM



Page 1

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 12/04/2010 Start Qty: 1.00

Required Date: 20/04/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

RT

Date: 10-4-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

=> m-h 10/04/21

10X

110

0.00



Brake NC

Memo

0.00

Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

=> m-h 10/04/21

10X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 12/04/2010 Start Qty: ~~1.00~~ ^{10.00}



Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: ~~1.00~~ ^{10.00}



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

⇒ M. L. 10/04/21

10X

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scalab3

X10
X10
X10
X10

140

0.00



Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: 111679

10X 10-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



Work Order ID 57645




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Item ID: D2332-041 Accept  Setup Start 
Revision ID:  Stop 
Item Name: Lid Prop Assembly 6.69" long
Start Date: 12/04/2010 Start Qty: ~~4.00~~ ^{10.00} 
Required Date: 20/04/2010 Req'd Qty: 1.00 ^{10.00} 
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(13)	10.04.27		
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(10)			
170  Small Fab Small Fab	Memo 1- Tumble 2- Assemble as per dwg D2332	0.00 0.00							

ES 10/04/28

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 12/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			8/10/04/28			(HLO)			
190 Packaging Packaging	Identify as per dwg & Stock Location: <u>518</u> Memo	0.00 0.00							
						10-4-28	SP	100	
200 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
						10/04/29	JS	10	
						BS 10-4-29			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1
3

Work Order ID: 57645



Parent Item: D2332-041



Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 12/04/2010

Required Date: 20/04/2010

Comments: IPP: B002.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.250		Purchased	No			100	f	15.4000	0.1053			
304 SS Round bar .250												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT028	15.4	
107387	15.4	

M304TR1.000W.049	Purchased	No				100	f	41.2137	0.4526			
304 RD Tube 1.00 x .049W												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT018	41.2137	
108756	12.08	
111457	29.1337	

M304TR0.500W.035	Purchased	No				110	f	0.0040	1.3158			
304 RD Tube .500 x .035W												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT017	0.004	
112800	0.004	

M/114354 ✓

m-k
1.0526 12/04/21
4-526 12/04/20
m-k
13. 1-3158
12/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 57645



Parent Item: D2332-041



Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 12/04/2010

Required Date: 20/04/2010

Comments: IPP: B002.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A		Purchased	No			170	Each	34.0000	1.0000			
Bolt												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST361

34

108138

6

111295

28

AN960JD416L

Purchased

No

170

Each

483.0000

3.0000



Washer



10 23 10/04/28 (10)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST346

483

110153

483

M13510

WASHER DO 416 J per
857 017

30 SA 10/04/28 (10)

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 57645



Parent Item: D2332-041



Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 12/04/2010

Required Date: 20/04/2010

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			170	Each	1,419.000	1.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST139	2	
111827	2	
Main Warehouse		
ST300	1417	
113422	425	
114108	984	
9063	8	

10 88 12/04/2010 (10)

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

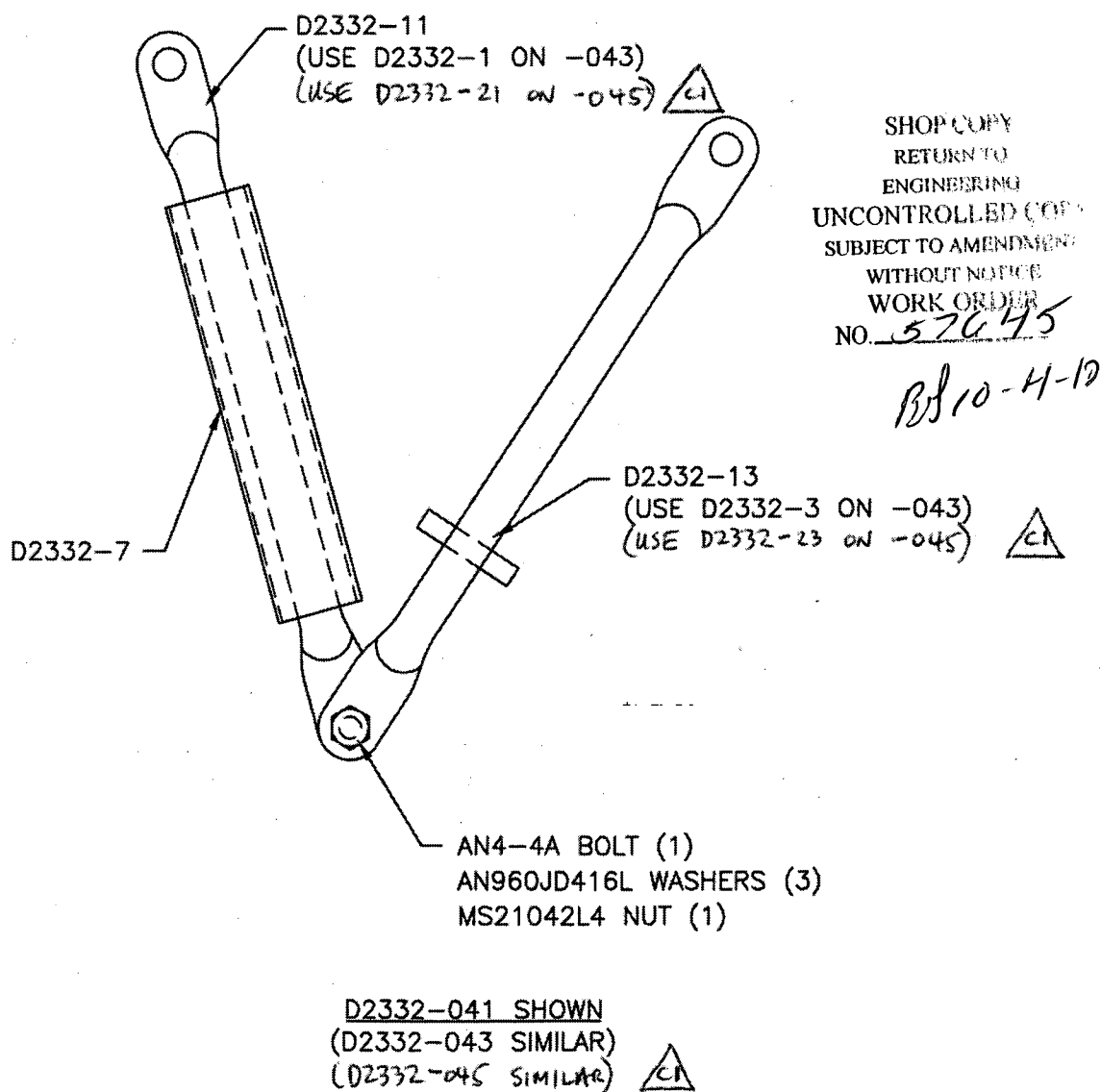
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY	SCALE NTS	
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

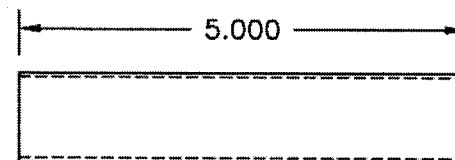
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

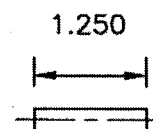
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332
DATE 03.07.03		TITLE LID PROP ASSEMBLY
		REV. C
		SHEET 2 OF 2
		SCALE 1:2
C1	03.08.06	ADD -045 PROP (7.25" LONG)
C	03.07.03	MAKE -041 PROP 6.69" LONG (576)
		MAKE -043 PROP 8.00" LONG (577)

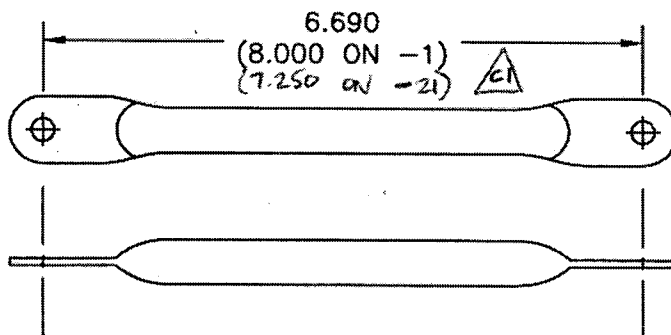


D2332-7 LOCKING COLLAR

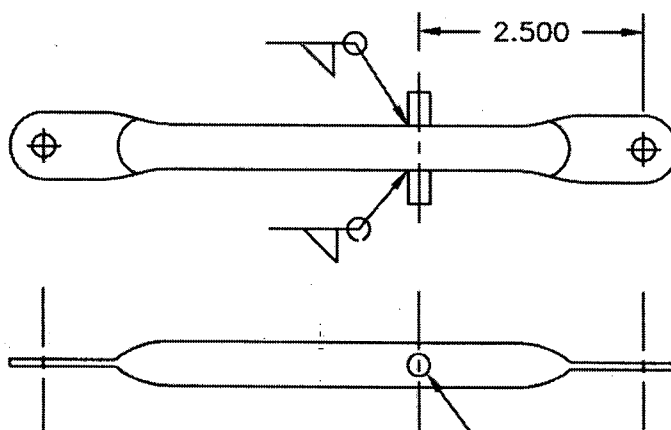


D2332-5 STOP PIN

w/b 57645



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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